

Date: Tuesday, 12/18/2007 10:45:51 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPRING
Job Number	: 36397		
Estimate Number	: 10497		
P.O. Number	: NIA	Part Number	: D2535
This Issue	: 12/18/2007 S.O. No. : NIA	Drawing Number	: D2535 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA	Drawing Revision	: A
Previous Run	: 34590	Material	: NIA
		Due Date	: 12/31/2007
Written By	: <u>JA</u>	Qty:	50 Um: Each
Checked & Approved By	: <u>JA 07.12.18</u>		
Comment	: Est. A 99.04.19 New Issue (From hand written IPP) DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5017

07/12/19

(50)

Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring

2.0	D2535P	Spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

JA 7/12/21 50

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
Check dims to dwg

JA 7/12/24 (50)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SI 36

JA 7/12/27 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/18/2007 10:45:51 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 36397

Part Number: D2535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



58

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/03

Job Completion



2008/1/2

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

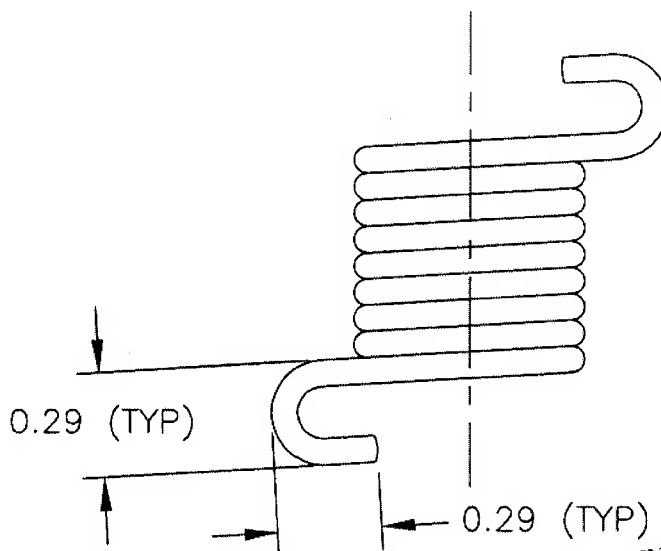
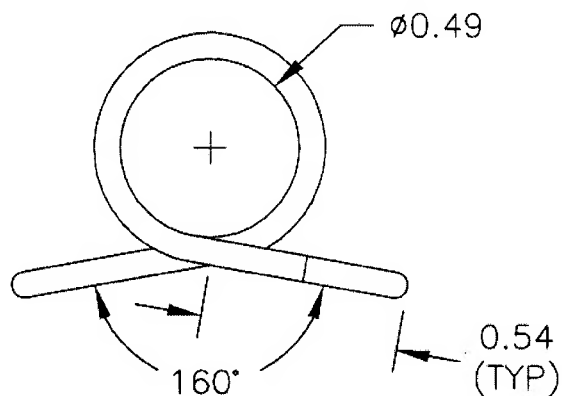
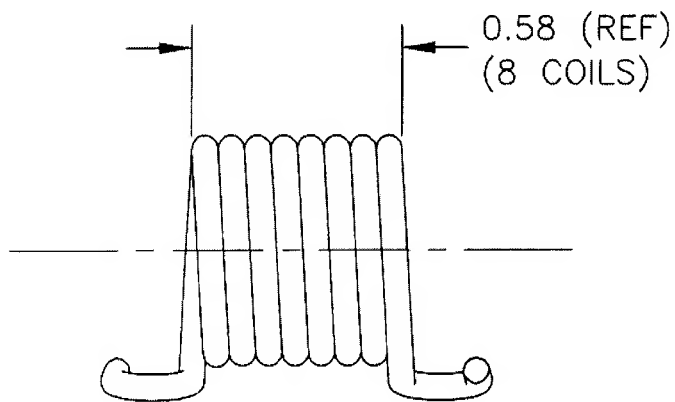
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36397

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#2 6104 - 82 Ave, Edmonton AB T6B 0E7
Tel: (780) 442-4020 • Fax: (780) 468-1946

INVOICE 17764

PRECISION COIL SPRINGS AND WIRE FORMS

BILL TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K1A 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
20-Dec-07		5317		Fed Ex 151793240	
QUANTITY		DESCRIPTION		UNIT	AMOUNT
50		D2535F1 Torsion Spring		4.56	228.00
<div>Thank you!</div> <div>WE APPRECIATE YOUR BUSINESS</div>					
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS	228.00		13.68	241.68

REPORT FOR: Dart Aerospace Ltd.		DATE: 12/20/2007
PO # 5317 5017	PART/DRAWING #: D2535P	
SPRING DESCRIPTION: Torsion Spring		QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	0.070"	Yes	
I.D.	.490"	0.495	
O.D.			
Number of Coils	8 Ref.	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per dwg.		
Rate (lb/in)			
Finish			

COMMENTS

Mill Certificate attached: N
Material Heat Number: NA

Certified by: Jeremy Burrows